

Date: Thursday, 05/03/2009 1:15:48 PM  
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
Job Number : 46312 -2  
Estimate Number : 10913  
P.O. Number :  
This Issue : 05/03/2009 S.O. No. :  
Prsht Rev. : NC  
First Issue : / / Type : LARGE FAB ASSY  
Previous Run : 46072  
Written By :  
Checked & Approved By :  
Comment : Est A 05.09.01 New issue KJ/JLM  
Est B 09.01.28 Rev b dwg EC verified by: DD

Drawing Name : LUG ASSEMBLY  
Part Number : D3405043  
Drawing Number : D3405 REV B  
Project Number : N/A  
Drawing Revision : B  
Material :  
Due Date : 12/03/2009

*Split for qty 6  
on this w/o i  
qty 14 cm - 1 remaining  
70905-11*

Qty: 20 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S11GA 304/316 0.125 Sheet



Comment: Qty.: 0.1617 sf(s)/Unit Total: 3.2340 sf(s)  
304/316 .125 Sheet  
(M304S11GA)  
Batch: 109358

*ml 09 03 05*

*(20)*

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET  
1-Cut as per Dwg D3405  
Dwg Rev: B  
Prog Rev: B

2-Deburr if necessary

*ml 09 03 05*

*(20)*

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*ml 09 03 05*

*(20)*

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

*8 09/03/06 counter (20)*

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE  
Deburr  
Form using DT8204 as per Dwg D3405

*SD 09/03/10*

## Process Sheet

omer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY

Job Number: 46312

Part Number: D3405043

Job Number:



Seq. #:	Machine Or Operation:	Description :
6.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		
7.0	D34041	GHW Lug
Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s) GHW Lug Pick: Qty Part number Description Batch 1 D3404-1 Lug <u>B45372</u> A/R SS Rod <u>n9676</u>		
Rev. <u>B</u> only		
8.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
Comment: LARGE FABRICATION RESOURCE 1 Weld as per Dwg D3405 Identify as D3405-043		
9.0	QC9	VISUAL WELDING INSPECTION
Comment: VISUAL WELDING INSPECTION		
10.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		
11.0	POWDER COATING	POWDER COATING
Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3.		
START TIME: <u>13:10</u> OVEN TEMPERATURE: <u>400°</u> FINISH TIME: <u>13:40</u>		
12.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		



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Part Number: D3405043

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 474

09/03/11 (x6)

14.0

QC21

FINAL INSPECTION/W/O RELEASE



09/03/11

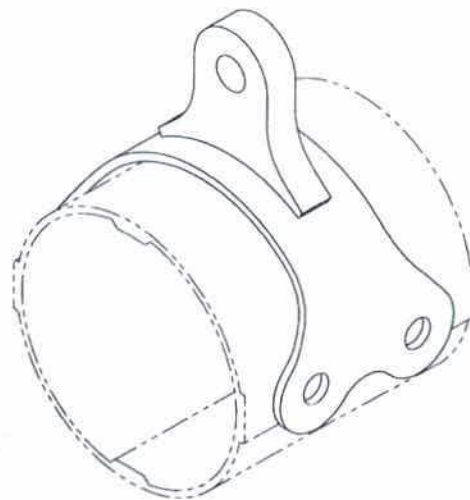
Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

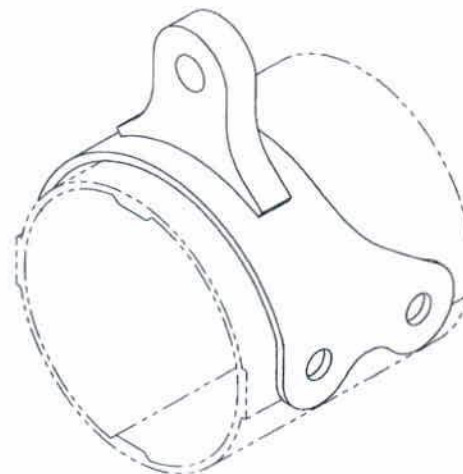


U 09.03.11

ITEM No.	QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
1	X		D3405-041	LUG ASSEMBLY
2		X	D3405-043	LUG ASSEMBLY
11	1	1	D3404-1	GHW LUG
12	1		D3405-1	GHW BRACKET
13		1	D3405-3	GHW BRACKET



**D3405-041 LUG ASSEMBLY**  
(SKID TUBE SECTION SHOWN  
FOR REF ONLY)

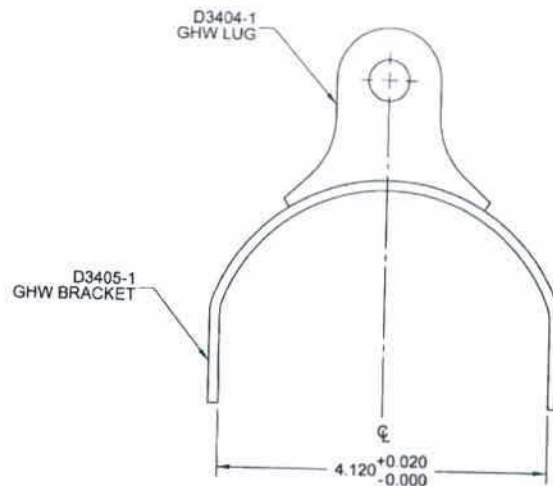


**D3405-043 LUG ASSEMBLY**  
(SKID TUBE SECTION SHOWN  
FOR REF ONLY)

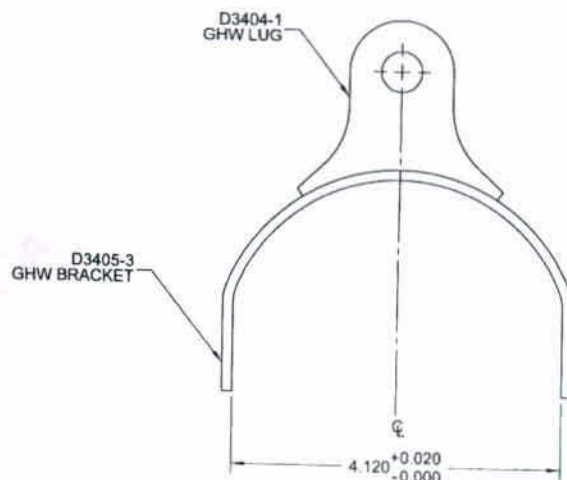
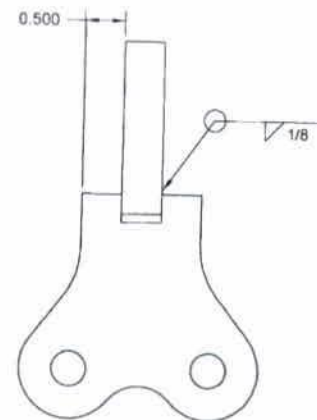
**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3405-041" USING FINE POINT PERMANENT INK MARKER  
IDENTIFY WITH DART P/N "D3405-043" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: -041, 0.85 lbs  
-043, 0.87 lbs

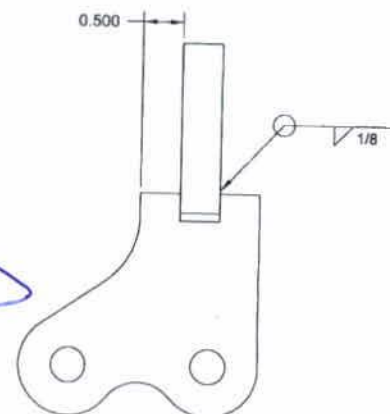
B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. FLAT PATTERNS FOR -1 & -3 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR198). SHEETS 3 & 4 ZONE A6 4.120 DIM WAS 4.100.		AJS	08.09.19
A	NEW ISSUE		PH	05.03.08
REV.	DESCRIPTION		BY	DATE
DESIGN	PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED		DRAWING NO.	REV. B	
MFG. APPR.		D3405	SHEET 1 OF 4	
APPROVED		TITLE	SCALE	
DE APPR.		GHW LUG ASSEMBLY	NTS	
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**D3405-041 LUG ASSEMBLY**



**D3405-043 LUG ASSEMBLY**



**RELEASED**  
6/12/18

DESIGN	PH	<b>DART AEROSPACE LTD</b>		
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA		
CHECKED		DRAWING NO.		REV. B
MFG. APPR.		D3405		SHEET 2 OF 4
APPROVED		TITLE		SCALE
DE APPR.		GHW LUG ASSEMBLY		NTS
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